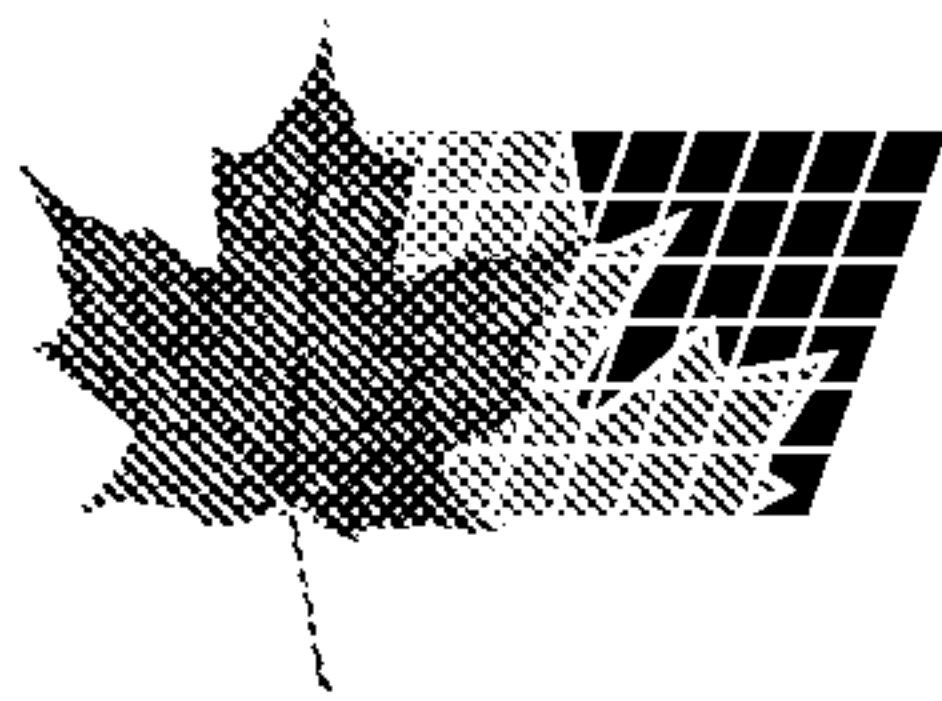




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(72) Fischer, Hans, CH

(73) NUEVA AG, CH

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(54) **METHODE DE PRODUCTION D'ARTICLES FORMES SUR UN
MATERIAU EN FIBRE RENFORCEE A PRISE
HYDRAULIQUE**

(54) **A METHOD OF PRODUCING FORMED ARTICLES OF A FIBER
REINFORCED, HYDRAULICALLY SETTING MATERIAL**

(57) At the method of producing formed articles of a fiber reinforced, hydraulically setting material the organic fibers are mineralized by aluminum sulfate and silica, the mixture processed with excess water to multilayered products, the laminates arrived therewith are then set in two steps and finally the formed articles produced treated by CO₂ for a pre-carbonization.

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Abstract

At the method of producing formed articles of a fiber reinforced, hydraulically setting material the organic fibers are mineralized by aluminum sulfate and silica, the mixture processed with excess water to multilayered products, the laminates arrived therewith are then set in two steps and finally the formed articles produced treated by CO₂ for a pre - carbonization.

A method of producing formed articles of a fiber reinforced, hydraulically setting material

Background of the invention

Field of the invention

The present invention relates to a method of producing formed articles of a fiber reinforced, hydraulically setting material in the Hatschek or flow-on method, whereby hydraulic binding agents, organic reinforcing fibers and process fibers and possibly filler materials are mixed with water in an amount of 250-500 % water based on the dry weight of the constituents.

Description of the prior art

Formed articles, specifically building parts such as e.g. plates or slabs, resp. consisting of a cement matrix with integrated reinforcement fibers, e.g. wood or cellulose are widely known.

The corresponding products are generally produced on the basis of wood and cement and contain a high portion of wood, namely 25-40 % (per weight). The wood fibers used are, thereby, relatively coarse (chippings). In case of products having several layers, the inner layers contain coarser fibers than the outer layers. The necessary compressing of the products is thereby relatively time consuming. Thin slabs have thereby the drawback of a low rigidity.

Slabs or plates for building constructions consisting of a mixture of wood chippings and cement and, furthermore, of chemical additives are known. In order to increase the bending strength glass fibers, cellulose fibers, synthetic fibers and mineral wool fibers are employed in addition to wood fibers.

During production attention must be paid to the correct orientation of the fibers.

It has, however, become obvious that until today it has been practically impossible to produce plates or slabs having merely a reinforcement of wood fibers which have a sufficient bending strength.

10 Conventional formed articles with reinforcing fibers of wood or other organic materials are not suitable to an exposure to weather influences if the fibers are not mineralized.

Summary of the invention

Thus, it is a general object of the present invention to provide a as simple as possible method of producing formed articles, of which the organic reinforcing fibers can be mineralised in a most simple way in order to give the product the desires rigidity also at specific environmental weather conditions.

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A further object is to provide a method of producing formed articles of a fiber reinforced hydraulically setting material in a Hatschek process whereby hydraulic binding agent and organic reinforcing fibers as constituents are mixed with water in an amount of 250-500% based on the dry weight of the constituents, comprising the steps of admixing aluminum sulfate and silica for mineralizing the organic reinforcing fibers,

30 thereafter processing said constituents with admixed aluminum to obtain multilayered parts with damp laminates,

presetting the damp laminates in molds in an environment of a high relative humidity and temperature, removing the laminates from the mold and letting them set for a plurality of days, and thereafter subjecting the laminates to temperatures between 45 and 125°C in a humid environment to a treatment by CO₂ thereby precarbonizing the laminates.

10 The addition of the aluminum sulfate leads to a change of the electrokinetic potential (Zeta - potential) of the fibers which makes the subsequent mineralizing of the organic fibers by the addition of the preferably amorphous silica (small amount suffice) possible. Therefore, in order to obtain a formed article of a high rigidity, cement, possible filler materials, coarse mineralized reinforcing fibers and fine process fibers are sufficient.

20 By the addition of CO₂ (injection, blowing in), the matrix is modified or the product precarbonized, resp., which has specifically a positive influence on the long term behavior under detrimental weather conditions. Preferably, CO₂ is added in an amount of 4-15% of volume which leads to a precarbonisation of 25-85%. The rigidity, specifically the bending strength, is achieved by the mineralisation of the organic reinforcing fibers.

Description of a preferred embodiment

30 The present invention will be better understood and objects other than those set forth come in mind when reading the following description of a preferred embodiment thereof.

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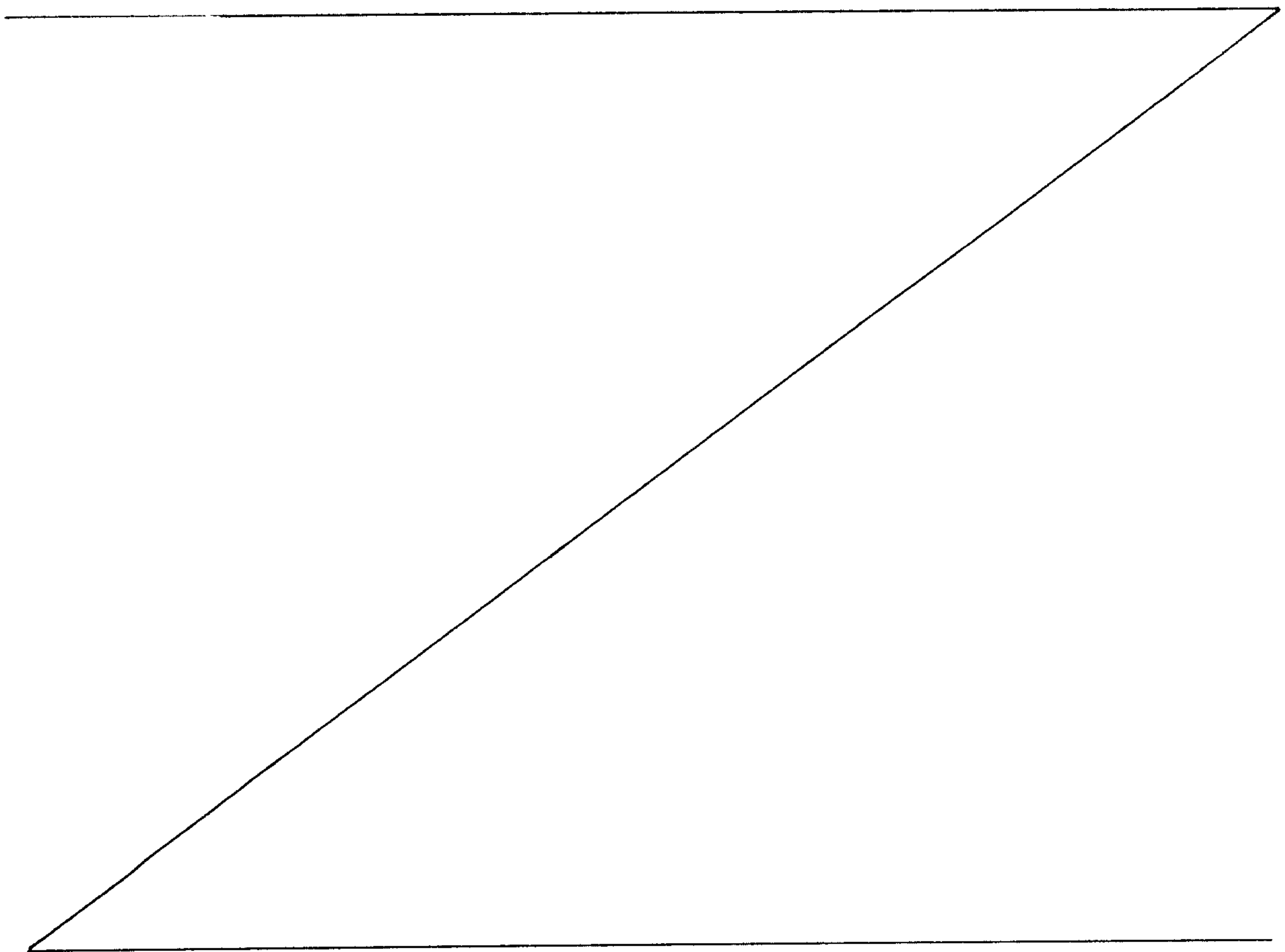
The length of the fibers amount to 0.2 - 6 millimeters,
preferably 0.3 - 4 millimeters.

For the producing of a formed article in accordance with the
invention for instance following mixture is used:

Binding agent (cement)	60 - 85 %
Filler materials	5 - 30 %
Organic and mineralized process fibers	1 - 5 %
Organic and mineralized reinforcement fibers	4 - 10 %

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Each formed article (plate or slab, resp.) can comprise due to
the treatment of the mixture according to the Hatschek or
flow-on process 5 to 50 layers of different thickness.



The formed articles, specifically building materials can find application as claddings, partitions, roof coverings and walls.

Products produced in accordance with the invention display following features:

Strength after 28 days	9 - 15 N/mm ²
Strength after 1 year	11 - 17 N/mm ²
Breaking energy after 28 days	1 - 4 KJ/m ²
Breaking energy after 1 year	2 - 5 KJ/m ²

Tested specimen (after 28 days):

Strength	10.8 N/mm ²
Density	1.09 kg/dm ³
Breaking energy	1.14 KJ/m ²
Modulus of elasticity	3.54 kN/mm ²
Grade of carbonization	45 %

Typical embodiments

1. Composition of the mixture

Binding agent (cement)	70 - 80 %
Filler materials (e.g. calcite)	8 - 25 %
Mineralized process fibers	1 - 14 %
Mineralized reinforcing fibers	6 - 10 %

2. Mineralisation of organic fibers

Pretreatment by aluminum sulfate	3 - 25 %
subsequent mineralisation by amorphous silica	4 - 30 %

(based on the dry weight of the fibers)

3. Pre - setting

9 - 18 hours at temperatures of 45 - 105 °C and a relative

humidity between 75 - 95 %.

4. Actual drying (Heat treatment)

$t = 50 - 110^{\circ}\text{C}$

$\text{CO}_2 = 5 - 12 \%$ (leads to a pre-carbonization of 30 - 80 %).

While there is described a present preferred embodiment, it shall be distinctly be understood that the invention is not limited thereto but can be variously practiced and embodied within the scope of the following claims.

WHAT IS CLAIMED IS:

1. A method of producing formed articles of a fiber reinforced hydraulically setting material in a Hatschek process whereby hydraulic binding agent and organic reinforcing fibers as constituents are mixed with water in an amount of 250-500% based on the dry weight of the constituents, comprising the steps of admixing aluminum sulfate and silica for mineralizing the organic reinforcing
10 fibers,
thereafter processing said constituents with admixed aluminum to obtain multilayered parts with damp laminates, presetting the damp laminates in molds in an environment of a high relative humidity and temperature, removing the laminates from the mold and letting them set for a plurality of days, and
thereafter subjecting the laminates to temperatures between 45 and 125°C in a humid environment to a treatment by CO₂ thereby precarbonizing the laminates.
- 20 2. The method of claim 1, comprising further the step of adding aluminum sulfate in an amount of 3-25% and silica in an amount of 4-30%, each based on the dry weight of the fibers.
3. The method of claim 1 or 2, wherein the presetting proceeds during 6 to maximal 20 hours at at least 40 to maximal 110°C and a relative humidity in the range between 60-97%.

4. The method of any one of claims 1 to 3, wherein the admixing step further comprises stabilizing the laminates at temperatures between 45 and 125°C.
5. The method of any one of claims 1 to 4, wherein CO₂ is added in an amount of 4-15% of volume which leads to a precarbonisation of 25-85%.
6. The method of any one of claims 1 to 5, wherein the organic reinforcement fibers consist of cellulose and have a length of 0.2-6 millimeters.
- 10 7. The method of claim 6, wherein the length of the reinforcement fiber is 0.3-4 millimeters.
8. The method of any one of claims 1 to 7, further comprising addition of filler materials selected from the group consisting of limestone powder, ashes and blast - furnace slag.
9. The method of any one of claims 1 to 8, wherein the following constituents by weight are used:
- | | |
|--|--------|
| binding agents | 60-85% |
| filler materials | 5-30% |
| 20 organic and mineralized process fibers | 1- 5% |
| organic and mineralized reinforcement fibers | 4-10% |
10. The method of any one of claims 1 to 9, wherein formed articles having 5 to 50 layers, are produces.
11. The method of claim 10, wherein the layers produced are of various thicknesses.

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12. The method of claim 1, wherein fiber materials are mixed with the constituents.

13. A formed article, produced in accordance with the method defined in any one of claims 1 to 12.